

Work Order ID 133856

133856

Page 1

Monday, June 22, 2015 9:24:18 AM

Item ID: D4464-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/15

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date: 5.6.22

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4464

H

100

Weld per dwg A/R Aluminum rod Batch: 413156200

100

Large Fab

Memo

0.00

Large Fab

1- Weld D4023-3 cap as per dwg D4464

Achtung!
Vor Einbau Sicherungstift herausnehmen
Attention,
remove safety pin before installation
Atenção!
Remova o pino de segurança antes de montar

①

DAS
23
9-89

JUN 22 2015

110

QC9- Inspect visual per QSI004- Fusión Welds

0.00

110

QC

Memo

0.00

Quality Control

JUN 22 2015

DAS
24
9-89

112

0.00

112

Small Fab

Memo

0.00

Small Fab

1- Wet install baffles to front and back panel using rivet and Proseal as per dwg
A/R Proseal Batch: M132226

JUN 22 2015

DAS
24
9-89

DAS
36
9-89

1x

15/06/23

Work Order ID 133856

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133856

Page 2

Item ID: D4464-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fuel Tank Assembly

Start Date: 6/22/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

114

QC

Memo

0.00

DAS

30

0.00

JUN 23 2015

Quality Control

Work Order ID 133856

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Page 3

Item ID: D4464-041

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N900040100

Setup Start ***NS1***

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Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 6/22/15 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Weld per dwg A/R Aluminum rod Batch: _____ 0.00

120

M131562

DAS
43 JUN 30 2015
9-89

Large Fab

Memo

0.00

Large Fab

1- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D3999-041/-043 doubler, ensure doubler and angle holes line-up for D4000-047

Transfer drill and c/sink D4975-1 bracket to bottom bracket, wet install as per dwg

Proseal 890B Batch: *M1322226*

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 and wet install with rivets as per dwg. ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG***

Proseal 890B Batch: *M1322228*

5- Install hinge wet with proseal as per dwg
A/R Proseal 890B Batch: *M1322228*

6-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

7-Weld top D4463-1 using DT9811 and DT9810

1A

15/06/30-89
DAS
36

1y

DAS
43
9-89

JUL 08 2015

Monday, June 22, 2015 9:24:18 AM

133856

Page 6

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/22/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/10/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

150

HandFinish

Memo

0.00

Hand Finishing

1- Alodine on tank. No alodine inside

DAS
41

9-89

15-7-9

0.00

160

OC

Memo

0.00

Quality Control

① 15.07.29. PD

0.00

164

Small Fab

Memo

0.00

Small Fab

1- Brush Proseal 890A on all internal sheet metal folds
Proseal 8990A Batch: M132226

2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B

A/R Proseal 890B Batch: *M132226*

~~DAS~~
36
C 89

Monday, June 22, 2015 9:24:18 AM

Page 7

PAINT BATCH: 131531

DAS
41
9-89

15-7-10

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133856

Page 8

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Revision ID:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

38
9-89

JUL 13 2015

190

0.00

190

Small Fab

Memo

0.00

Small Fab

1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg

2- Abrade surface with red scotch brite and install cushion using contact cement

A/R Contact Cement Batch: M1310121300L

1X 15/07/13 DAS 36 9-89

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

① DAS 38 9-89

JUL 13 2015

Picklist Print

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG
REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG
REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG REV.F DD
VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD
VERF:JLM IPP REV:H 15.03.04 AS PER DWG REV.H9 DD
VERF:JLM IPP REV:I 15.06-17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD4-6 *MS20470AD4-6* RIVET		Purchased	No				Each	2,021.000		8		15/06/30	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CCK004		2021							
				m131618		2021							
D3997-5 *D3997-5* Placard		Manufactured	No			190	Each	41.0000	2	2		15/07/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST076		41							
				72611		41							
D3997-11 *D3997-11* Placard		Manufactured	No			190	Each	24.0000	1	1		15/07/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST077A		24							
				106884		7							
				107679		5							
				127110		12							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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133856

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D3997-17

Manufactured No

190 Each 22.0000 1 1

D3997-17

Placard

**

DAS
36
9-89
15/07/13

Location

Loc Qty

Loc Code

ST077A

22

106785

1

107632

9

129866

12

D3997-29

Manufactured No

190 Each 14.0000 1 1

D3997-29

Placard

**

DAS
36
9-89
15/07/13

Location

Loc Qty

Loc Code

ST077A

14

106864

2

127111

12

D3997-43

Manufactured No

190 Each 25.0000 1 1

D3997-43

Placard

**

DAS
36
9-89
15/07/13

Location

Loc Qty

Loc Code

ST077A

25

106642

4

107558

9

127112

12

D3999-7

Manufactured No

120 Each 11.0000 1 1

D3999-7

Corner

**

DAS
43
9-89
JUN 22 2015

Location

Loc Qty

Loc Code

WA003

11

108621

4

123147

2

124513

1

130069

4

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4000-1

Manufactured No

120

Each

11.0000

1

1

D4000-1

Fuel Supply Fitting

DAS
36
9-89

15/06/30

Location

Loc Qty

Loc Code

GA

11

128349

3

128899

8

1

✓ D4000-5

Manufactured No

120

Each

15.0000

1

1

D4000-5

Fuel Tank Vent Fitting

DAS
43
9-89

JUN 22 2015

Location

Loc Qty

Loc Code

WA003

15

106917

5

107388

5

130055

5

1

D4000-9

Manufactured No

120

Each

28.0000

3

3

D4000-9

Grommet

DAS
36
9-89

15/06/30

Location

Loc Qty

Loc Code

WA003

28

106808

14

123024

14

3

D4000-045

Manufactured No

120

Each

3.0000

1

1

D4000-045

Fuel Pickup Fitting Assembly

DAS
36
9-89

15/06/30

Location

Loc Qty

Loc Code

WA003

3

122673

3

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Page 4

Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4008-11

Manufactured No

120

Each

15.0000

1

1

DAS
36
9-89

D4008-11

Hinge Half

**

15/06/30

Location

Loc Qty

Loc Code

GA

12

129867

12

WA003

3

122600

3

D4008-041

Manufactured No

190

Each

10.0000

1

1

DAS
36
9-89

D4008-041

Fuel Filler Splash Guard Assembly

**

15/07/13

Location

Loc Qty

Loc Code

ST249

4

130040

4

ST249A

6

124463

1

127687

1

128582

4

✓ D4023-3

Manufactured No

190

Each

14.0000

1

1

DAS
43
9-89

D4023-3

Cap And Flange

**

JUN 22 2015

Location

Loc Qty

Loc Code

WA003

14

106700

2

120208

4

129761

5

130907

1

132479

2

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected-Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4025-5

Manufactured No

190

Each

15.0000

1

1

D4025-5

Fuel Quantity Sender

**

DAS
36
9-89

15/07/13

Location

Loc Qty

Loc Code

ST232B

15

106832

3

121582

1

127571

3

129924

4

132650

4

1

D4057-1

Manufactured No

120

Each

55.0000

3

3

D4057-1

Retaining Ring

**

DAS
36
9-89

15/06/30

Location

Loc Qty

Loc Code

WA003

55

106766

8

107269

47

3

D4062-041

Manufactured No

190

Each

5.0000

1

1

D4062-041

Tank Support Assembly

**

DAS
36
9-89

15/07/13

Location

Loc Qty

Loc Code

prelim

4

128383

4

WA003

1

122513

1

1

D4125-1

Manufactured No

120

Each

6.0000

1

1

D4125-1

Fwd Sediment Bowl

**

DAS
43
9-89

JUN 22 2015

Location

Loc Qty

Loc Code

WA003

6

130323

6

1

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

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Page 6

Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4125-3

Manufactured No

120

Each

9.0000

1

1

DAS

43

9-89

JUN 22 2015

✓ ***D4125-3***

Aft Sediment Bowl

**

Location

Loc Qty

Loc Code

WA003

9

130324

9

D4404-5

Manufactured No

120

Each

8.0000

2

2

**

D4404-5

Cushion, Fwd

Location

Loc Qty

Loc Code

ST517

8

121948

1

127570

5

129922

2

D4462-1

Manufactured No

112

Each

5.0000

1

1

**

✓ ***D4462-1***

Baffle

Location

Loc Qty

Loc Code

WA003

5

129269

1

129984

4

D4462-3

Manufactured No

112

Each

6.0000

1

1

**

✓ ***D4462-3***

Baffle

Location

Loc Qty

Loc Code

WA003

6

129270

3

130041

3

DAS

43

9-89

JUN 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4463-041

Manufactured No

120

Each

3.0000

1

1

DAS
43
9-89

JUN 22 2015

D4463-041

Tank Top Assembly

**

Location

Loc Qty

Loc Code

WA003

3

127344

3

①

D4463-3

Manufactured No

120

Each

8.0000

1

1

DAS
43
9-89

JUN 22 2015

D4463-3

Tank Aft End

**

Location

Loc Qty

Loc Code

WA003

8

122835

1

①

123531

2

130066

5

D4463-5

Manufactured No

120

Each

23.0000

1

1

DAS
43
9-89

JUN 22 2015

D4463-5

Tank Upper Cut Out

**

Location

Loc Qty

Loc Code

WA003

23

106751

14

120923

3

①

121024

6

D4463-7

Manufactured No

120

Each

7.0000

1

1

DAS
43
9-89

JUN 22 2015

D4463-7

Tank Fwd End

**

Location

Loc Qty

Loc Code

WA003

7

121172

2

123128

2

130052

3

①

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4463-9 Manufactured No

112 Each 5.0000 1 1

DAS

✓ ***D4463-9***

Tank Back

★★

43

9-89

JUN 22 2015

Location

Loc Qty

Loc Code

WA003

5

127752

5

D4463-11 Manufactured No

112 Each 7.0000 1 1

DAS

✓ ***D4463-11***

Tank Front

★★

43

9-89

JUN 22 2015

Location

Loc Qty

Loc Code

WA003

7

127699

5

128253

2

D4463-13 Manufactured No

190 Each 6.0000 1 1

DAS

✓ ***D4463-13***

Tank Bottom

★★

43

9-89

JUN 22 2015

Location

Loc Qty

Loc Code

WA003

6

123120

1

129425

5

D4577-041 Manufactured No

190 Each 8.0000 1 1

DAS

✓ ***D4577-041***

Fwd Access Panel Assembly

★★

36

9-89

15/07/13

Location

Loc Qty

Loc Code

ST234

8

106703

8

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4577-1

Manufactured No

190

Each

6.0000

1

1

D4577-1

Rear Access Panel

DAS
36
9-89

15/07/13

Location

Loc Qty

Loc Code

ST233A

6

106923

2

121178

1

124494

3

D4577-3

Manufactured No

190

Each

5.0000

1

1

D4577-3

Middle Access Panel

DAS
36
9-89

15/07/13

Location

Loc Qty

Loc Code

ST233A

4

106697

3

120991

1

WA003

1

128100

1

D4968-1

Manufactured No

190

Each

3.0000

1

1

D4968-1

Side Cushion

DAS
36
9-89

15/07/13

Location

Loc Qty

Loc Code

prelim

1

110413

1

ST400

2

120927

1

131888

1

6/33967
(1X)

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4975-1

Manufactured No

Each

4.0000

1

D4975-1

Bracket

DAS

36

9-89

15/07/13

Location

Loc Qty

Loc Code

WA003

4

120928

1

128259

1

131674

2

AN3-5A

Purchased

No

Each

509.0000

24

AN3-5A

Bolt

DAS

36

9-89

15/07/13

Location

Loc Qty

Loc Code

CA

135

m129682

135

FP001

19

124561

4

m130325

15

GA

355

m129507

2

m131420

353

AN3H5A

Purchased

No

Each

27.0000

5

AN3H5A

Bolt

DAS

36

9-89

15/07/13

Location

Loc Qty

Loc Code

ST350

27

m127044

27

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, June 22, 2015 9:24:54 AM

Page 11

Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

AN3-7A Purchased No

Each 176.0000 4

AN3-7A

Bolt

DAS

36

9-89

Location

Loc Qty

Loc Code

ST349

176

131420

169

M129706

7

MS20426AD4-4

Purchased No

Each 3,631.000

MS20426AD4-4

Rivet

DAS

36

9-89

Location

Loc Qty

Loc Code

GA

413

125445

413

ST310

3030

m132536

3030

ST312

188

125445

188

MS20470AD4-4

Purchased No

Each 1,816.000

MS20470AD4-4

Rivet, Universal Head

DAS

36

9-89

Location

Loc Qty

Loc Code

GA

1803

M132536

1803

ST310

13

118614

13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Monday, June 22, 2015 9:24:55 AM

Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

190

Each

2,020.000

4

4

MS21042L3

Nut

15/07/13

DAS
36
9-89

Location

Loc Qty

Loc Code

FP001

411

M130922

411

GA

461

M131317

461

ST305

1148

116549

12

126333

49

M128754

2

M131264

24

M132123

61

M132382

1000

4

NAS1149D0332J

Purchased

No

190

Each

1,732.000

13

13

NAS1149D0332J

Washer

15/07/13

DAS
36
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1028

m130325

930

m131624

98

ST270

690

m132189

690

13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, June 22, 2015 9:24:55 AM

Page 13

Work Order ID: 133856

133856

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/22/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

1,744.000

24

24

NAS1149D0363J

Washer

DAS
36
9-89

15/07/13

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

168

m128429

168

ST269

1007

m126319

7

m132317

1000

132677

24x

* NAS1149D0316J

QTY: 1X

M 127956

15/07/13

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR-No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-3	FUEL CAP AND FLANGE
14	1	D4025-5	FUEL SENDER
15	3	D4057-1	RETAINER
16	1	D4062-041	TANK SUPPORT
17	1	D4125-1	FWD SEDIMENT BOWL
18	1	D4125-3	AFT SEDIMENT BOWL
19	2	D4404-5	CUSHION, FWD
20	1	D4462-1	BAFFLE
21	1	D4462-3	BAFFLE
22	1	D4463-041	TOP TANK ASSEMBLY
23	1	D4463-3	TANK AFT END
24	1	D4463-5	TANK UPPER CUT OUT
25	1	D4463-7	TANK FORWARD END
26	1	D4463-9	TANK BACK
27	1	D4463-11	TANK FRONT
28	1	D4463-13	TANK BOTTOM
29	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
30	1	D4577-1	REAR ACCESS PANEL
31	1	D4577-3	MIDDLE ACCESS PANEL
32	1	D4968-1	CUSHION, SIDE
33	1	D4975-1	ANGLE BRACKET
34	24	AN3-5A	BOLT
35	5	AN3H5A	BOLT
36	4	AN3-7A	BOLT
37	4	MS20426AD4-4	RIVET, CSK
38	165	MS20470AD4-4	RIVET, PANHEAD
39	8	MS20470AD4-6	RIVET, PANHEAD
40	4	MS21042L3	NUT
41	13	NAS1149D0332J	WASHER
42	24	NAS1149D0363J	WASHER

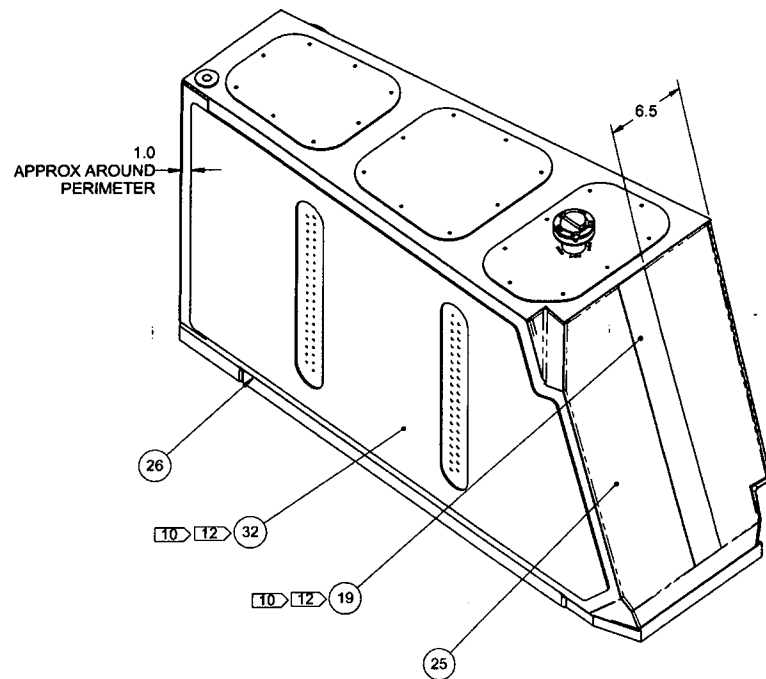
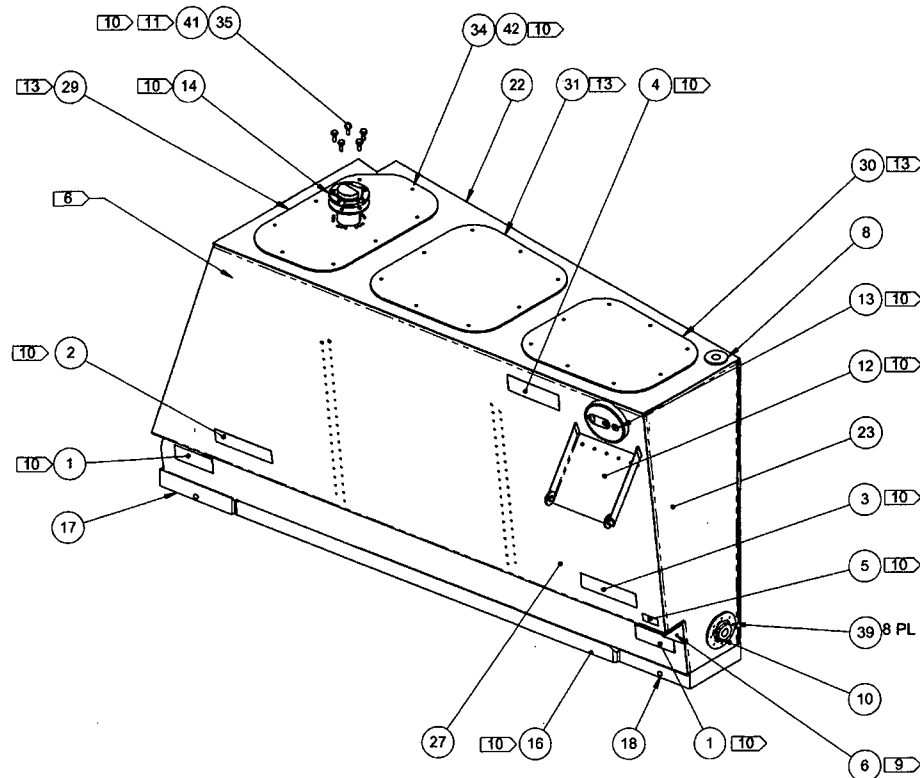
RELEASED
R 2015-06-18
ECN 15-583

H	REPLACED NOTE 8 (SHT 2), ADDED NOTE 14 (SHT 2), ADDED AUXILIARY VIEW (SHT 3), ADDED NOTE 15 (SHT 4), REPLACED NOTE 13 (SHT 5), SHT 4 WAS SHT 3, SHT 5 WAS SHT 4, REMOVED D4124-1 TABS & AN3-6A BOLTS, CHEMICAL CONVERSION COAT NOW AFTER WELDING (SHT 5), ADD AN3-7A BOLTS	CC	15.02.06
G	FINISH "FLAT GREY" WAS "GREY" (SHT 2); PICTORIAL UPDATE FOR D4000-1 & D4462-1	AP	14.12.05
F	AN3-5A WAS AN3C4A QTY. 24 (ZN D6-2) AN3H5A WAS AN3-5A QTY. 5 (ZN D7-2) MS20470AD4-6 WAS MS20426AD4-6 QTY. 8 (ZN B5-2) D4000-1 IS NO LONGER INSTALLED WITH COUNTERSUNK RIVETS UPDATE NOTE 10 ON SHEET 3	ML	14.06.27
E	UPDATED -041 WITH RE-DESIGNED D4463-3/-9/-11 AND D4462-1/-3 D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35206-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B6-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	CC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY

NOTES:

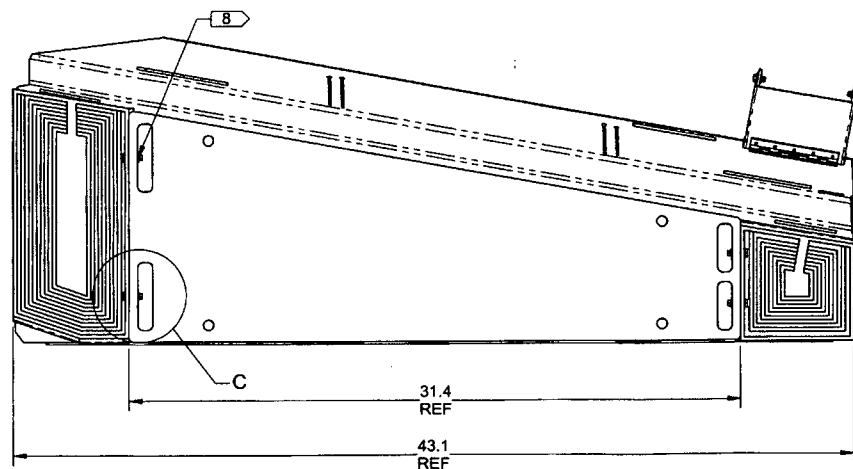
- 1) MATERIAL: N/A
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 39.52 lbs
- 8) LPI AND PRESSURE TEST PER DART QSI 038 6.3
- 9) MASK PRIOR TO FINISH
- 10) INSTALL AFTER FINISH
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-1/-3 ACCESS PANELS WET WITH PROSEAL P/S 890B.

RELEASED
2015-06-18

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	CC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

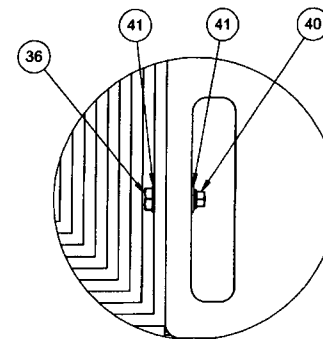
8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY
AUXILIARY VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRANSFER DRILL HOLES FROM D4125-1/-3 SEDIMENT BOWLS TO D4062-041 TANK SUPPORT ASSEMBLY

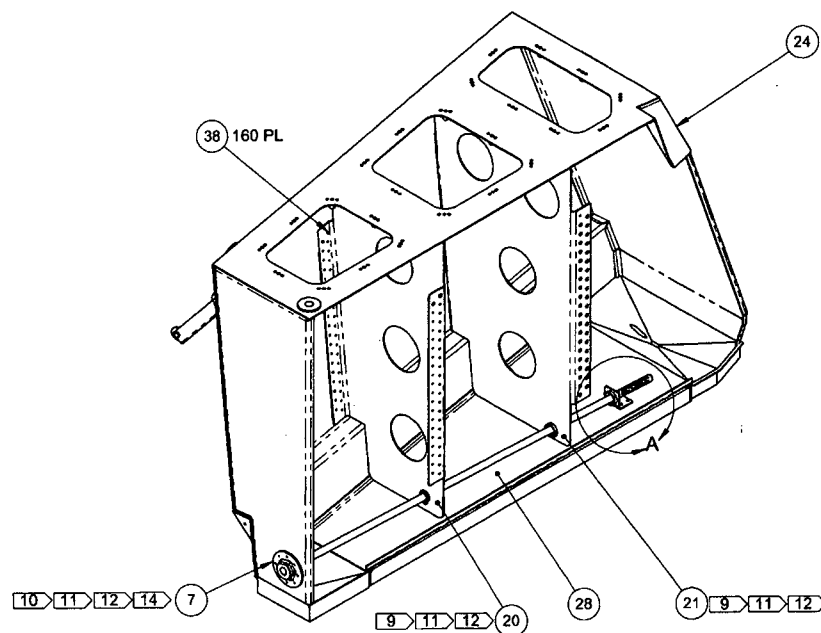


DETAIL C
SCALE 3X

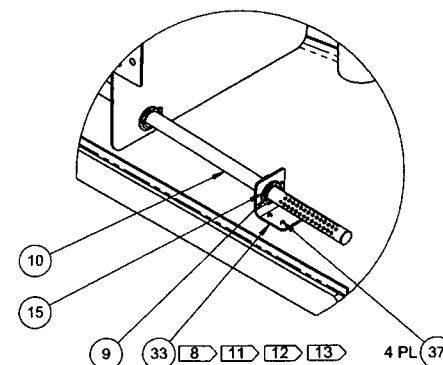
RELEASED
2015-06-18

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



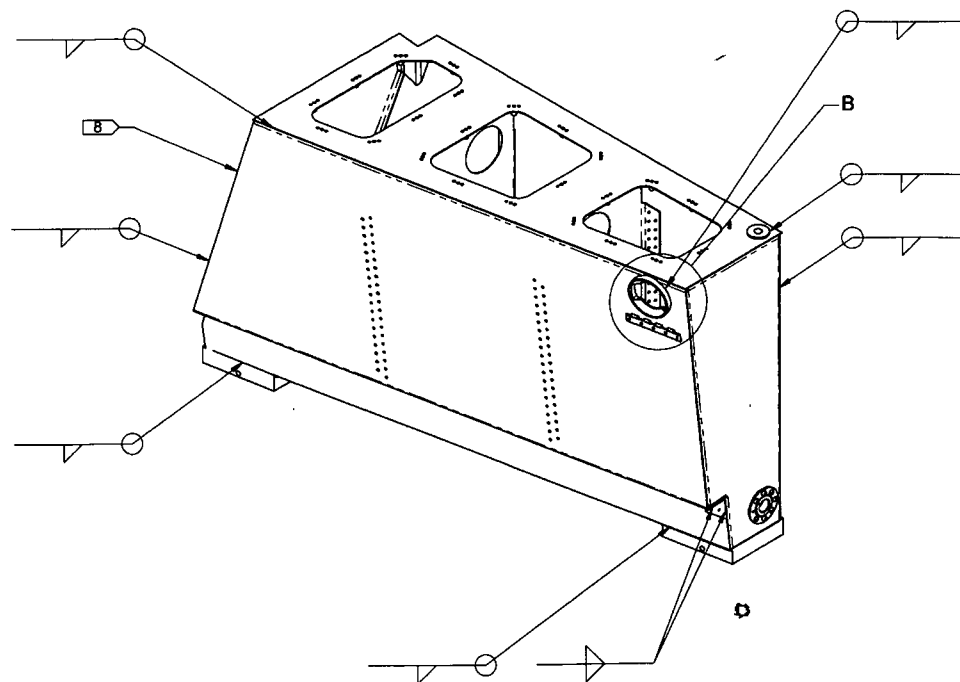
DETAIL A
ROTATED FOR CLARITY
SCALE 2X

NOTES:

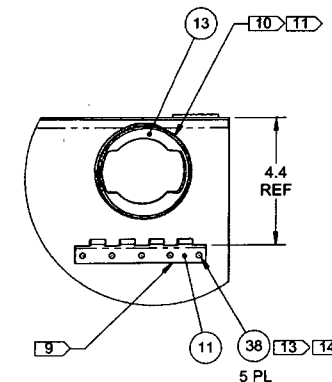
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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\varnothing 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\varnothing 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK
- 14) INSTALL D4000-1 FITTING WITH FLAT FACING UPWARDS
- 15) BRUSH PROSEAL 890A ON ALL INTERNAL SHEET METAL FOLDS

RELEASED
2015-06-16

APPROVED	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	CC		
	CHECKED	AP	DRAWING NO.	REV. H
	MFG. APPR.	DD	D4464	SHEET 4 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	TANK ASSEMBLY	NTS
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D4464-041 FUEL TANK ASSEMBLY
WELDING AND RIVETING DETAIL



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 14) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

RELEASED
2015-06-16

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29070**

Purchase Order Date 7/9/2015

PO Print Date 7/10/2015

Page Number 1 of 3

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71401-45	procurement quality clauses	7/10/2015 No 7/10/2015		1.00	\$0.00	\$0.00
	PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A020 NON - DESTRUCTIVE TEST/INSPECTION IDENTIFICATION A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS						
Line Total:							\$0.00
2	133856	D4464-041 FUEL TANK	7/10/2015 Yes 7/10/2015		1.00	\$202.50	\$202.50
	LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						
Line Total:							\$202.50

CL JUL 10 2015 1

Note:

7/10/2015



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO25174	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 29070
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 4 CROSSTUBES AND 1 FUEL TANK ASSY

ITEM ID: D212-664-101 FWD CROSSTUBE HIGH

1 - WORK ORDER ID#: 133589

2 - WORK ORDER ID#: 133588

3 - WORK ORDER ID#: 134124

4 - WORK ORDER ID#: 133590

ITEM ID: D4464-041 FUEL TANK ASSEMBLY

5 - WORK ORDER ID#: 133856

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-5) AS PER ASTM1417M-13						9 July 2015	
NO CRACK FOUND							
Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp	Date:
Name:			9 July 2015